

26

Date: Monday, 5/28/2007 11:56:42 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE
 Job Number : 32522
 Estimate Number : 12877
 P.O. Number : N/A
 This Issue : 5/28/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 32522
 Part Number : D412742011
 Drawing Number : IIN D412-742 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 6/30/2007 Qty: 1 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature] 07.05.28
 Comment : Est Rev: A 05.10.13 New Issue KJ/JLM
 Est Rev: B 06-06-08 As per DSI9336 JLM
 Est Rev: C 07-05-28 As per Rev C JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07/06/08

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-011 CHG003

E 07/06/08

2.0 32522A FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-041 B 32522A

3.0 D412742015 Electric Step Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Electric Step Kit

Batch: 32612

SP

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2571 Saddle Fwd Outside

334362

SP

5.0 D2572 Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2572 Saddle Fwd Inside

334368

7/1/08 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 32522

Part Number: D412742011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2573 Saddle Aft Outside

133484

50

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2574 Saddle Aft Outside

133485

50

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2876 Saddle Spacer

1329789

50

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2877 Saddle Spacer

1332104

50

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description

Batch

16 D3403-1 Bushing

1333786

50

11.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

Batch

4 D2747 Bolt

1333770

7/11/02 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 32522

Part Number: D412742011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Set Screw
BATCH: 128093 *SP*

13.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick:
Qty Part Number Description Batch
16 AN4C6A Bolt M105426 *SP*

14.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part Number Description Batch
8 D3403-3 Bushing M334009 *SP*

15.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-041 GHW Lug M32890 *SP*

16.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3405-043 GHW Lug M32891 *SP*

17.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:
Qty Part Number Description Batch
4 AN4C46A Bolt M19529 *7/11/02 SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 32522

Part Number: D412742011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

M19572

M103914

SD

19.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

M104289

SD

20.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

H 32 AN960C416L

Washer

M100651

SD

21.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C616L

Washer

M18822

SD

22.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M105793

7/11/02 SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 5/28/2007 11:56:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 32522

Part Number: D412742011

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

NAS1515H4L

Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 NAS1515H4L

Washer

** 4105408*

SD

24.0

NAS1515H6L

Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H6L

Washer

418918

SD

25.0

NAS1515H7L

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H7L

Washer

4100727

4100727 SD

26.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

43400

SD

27.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

43359

7/11/02 SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Monday, 5/28/2007 11:56:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 32522

Part Number: D412742011

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

1333276

SD

29.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 1101427

7/11/02

SD

(IX)

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 7/11/02

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-011

Location: D

7/11/07

(1)

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/11/07 (1)

Job Completion



UL 07-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/28/2007 11:57:11 AM
 User: Kim Johnston

Process Sheet

26

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Job Number	: 32522A		
Estimate Number	: 12876		
P.O. Number	: <i>N/A</i>	Part Number	: D412742041
This Issue	: 5/28/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3391 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: F
Previous Run	: 32522A	Material	: <i>N/A</i>
Written By	: <i>KA</i>	Due Date	: 6/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>KA 07.05.08</i>		
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM		
	: Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC		
	: Est Rev:C 07-05-28 As per Rev F JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-041 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-041 CHG003 *N/A*

2.0

D3391013

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch
 1 D3391-013 Mid Tube Assembly

Batch

*B32235**m. l. / BIL*

3.0

D3391015

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch
 1 D3391-015 Aft Tube Assembly

Batch

*B32594**m. l. / BIL*

4.0

D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

*533798**m. l. / BIL 07/11/07**(1X)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 32522A

Part Number: D412742041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B 34052

m.l. / BR

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B 34806

m.l. / BR

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B 34353

m.l. / BR

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 34354

m.l. / BR

9.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: M 106043

m.l. / BR

10.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: M 105057

m.l. / BR

11.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: M 103668

BR / m.l. 07/11/07

(IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 32522A

Part Number: D412742041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: M105143

m-l / BR

13.0

MS27039C412

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch: M12726

m-l / BR

14.0

NAS1515H4L

Inventory



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

Batch: M105408

m-l / BR

15.0

AN960C416L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M105793

m-l / BR

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M105005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment, using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M105585
Expiry date: 08/07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251
A/R Sikaflex-241/-291 M105585
Expiry date: 08/07

4-Remove "T" pins once sikaflex is dry.

(IX)

07/11/07

m-l / BR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 32522A

Part Number: D412742041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/11/07

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-041

Location:

PPP Rev:

PPP 35522

07/11/07

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/07

Job Completion



07/11/07

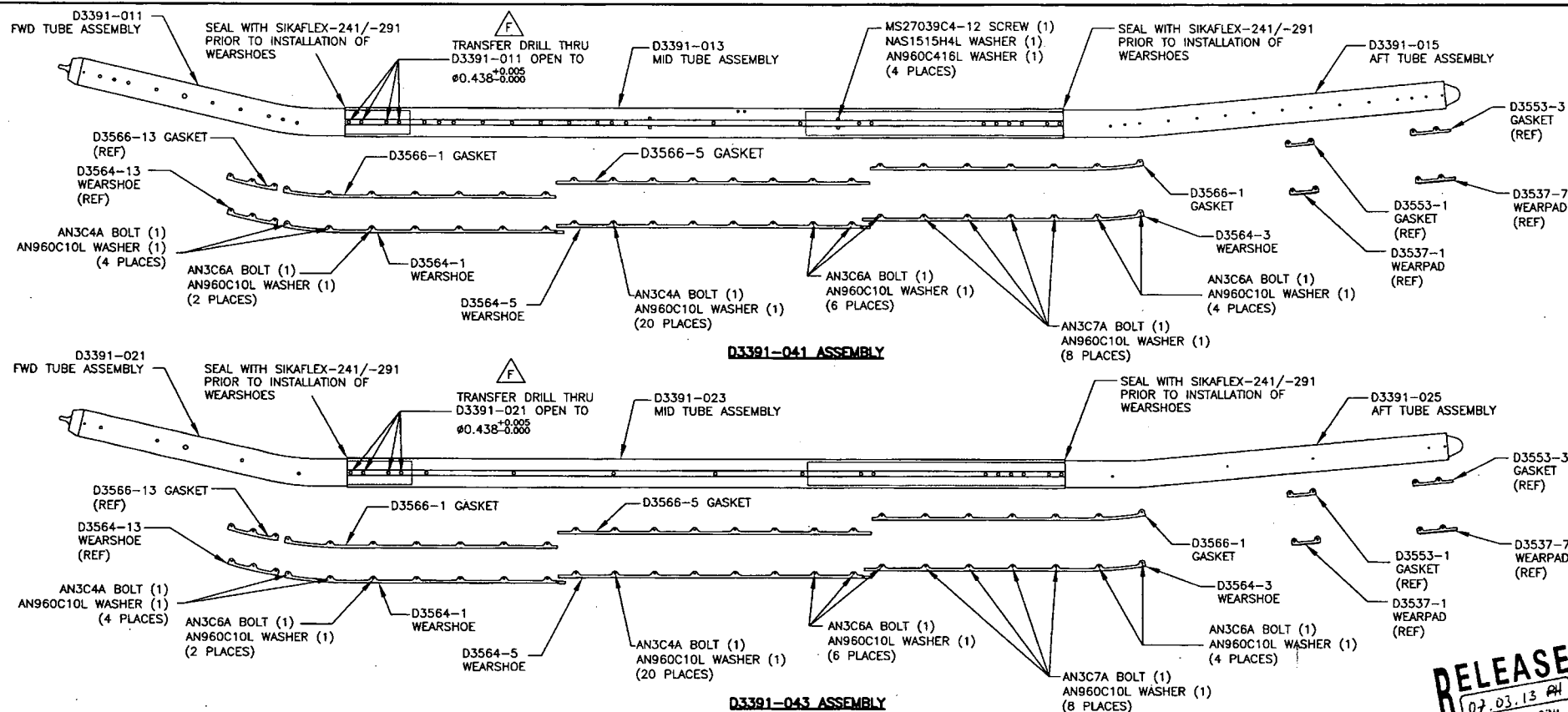
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (0.250-0.257) FOR WEARSHOE INSERTS. C'SINK 0.391/0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

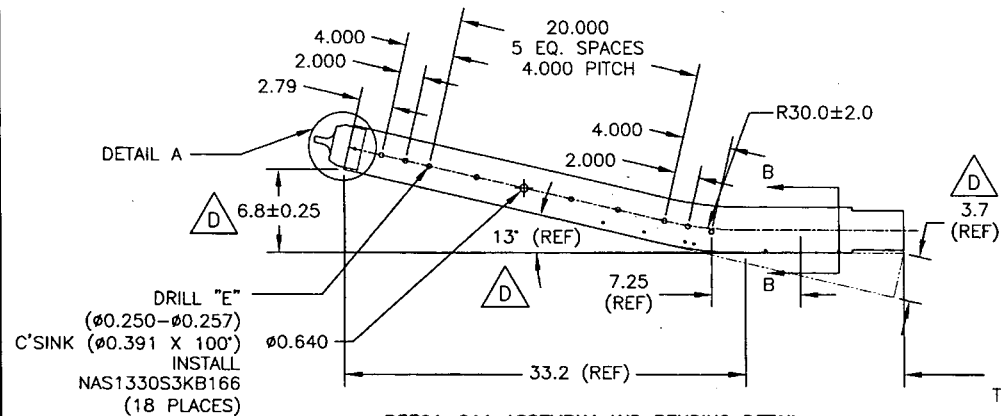
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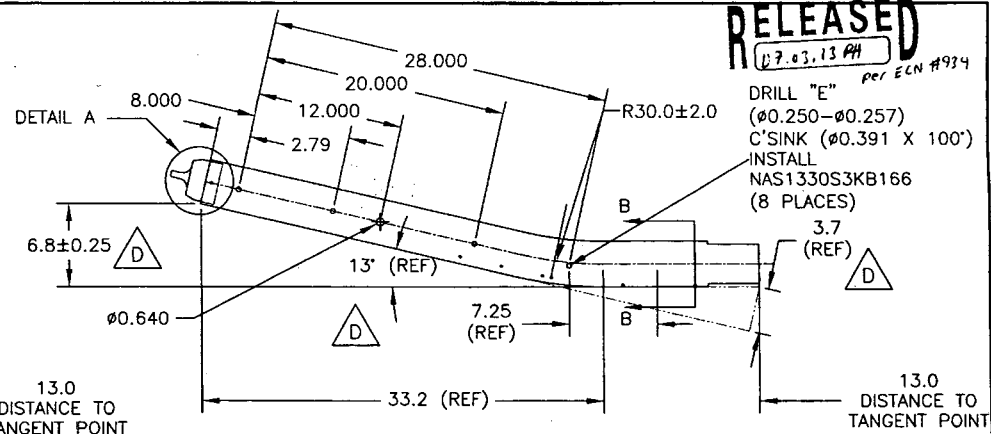
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE
		DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3391
		REV. F
		SHEET 1 OF 5
		SCALE
		NTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
325224

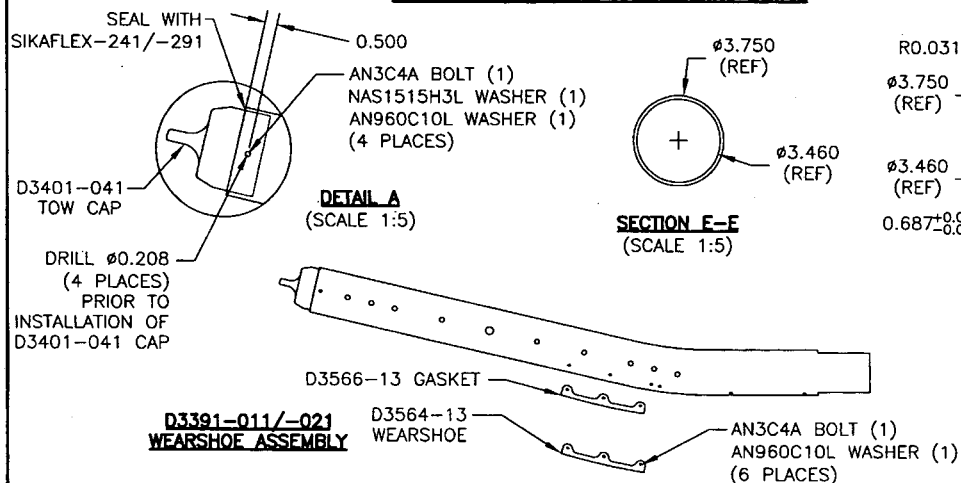
RELEASED
127.03.13 PH
per ECN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL



D3391-011/-021 WEARSHOE ASSEMBLY

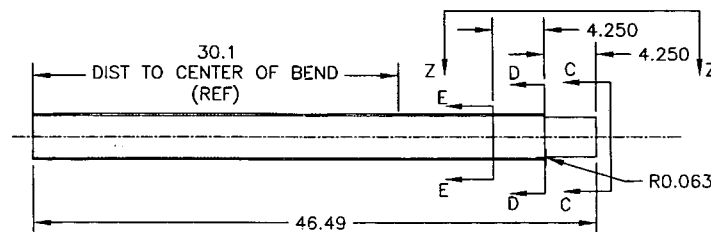
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

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5
DRILL "E"
(Ø0.250-Ø0.257)
C'SINK (Ø0.391 X 100')
INSTALL
NAS1330S3KB166
(12 PLACES)

SECTION B-B
(SCALE 1:5)

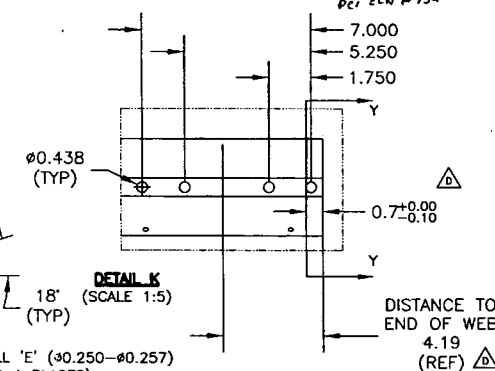
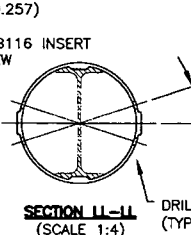
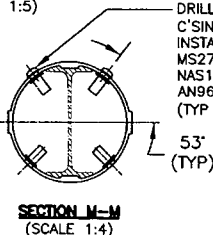
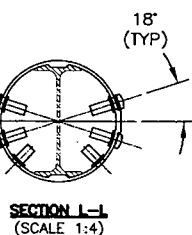
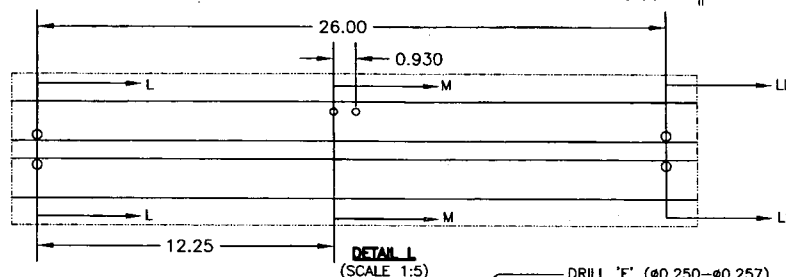
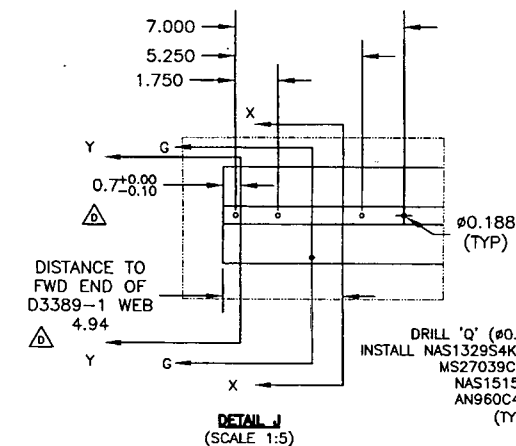
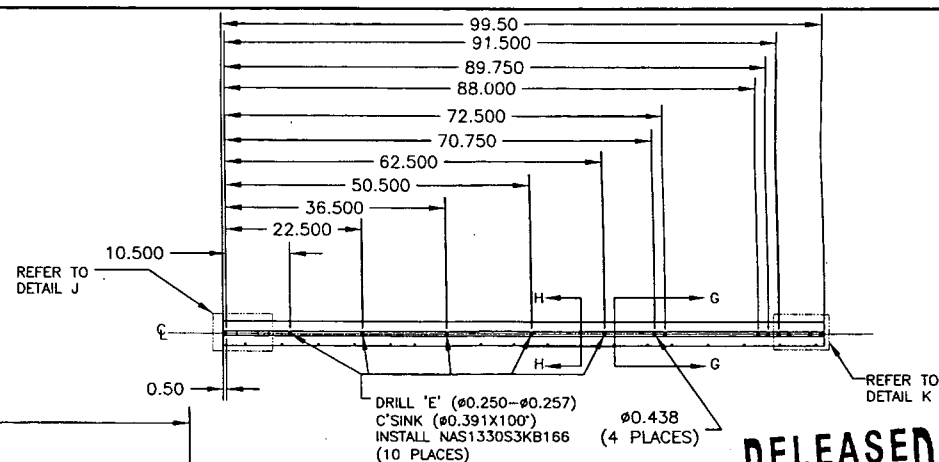
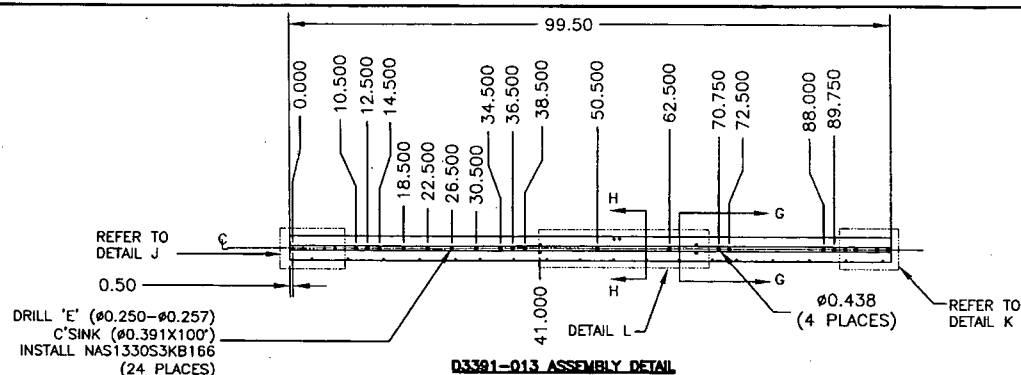


D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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		D3391	SHEET 2 OF 5
DATE	TITLE	SCALE	
07.01.18	412 FLOAT SKIDTUBE	1:10	



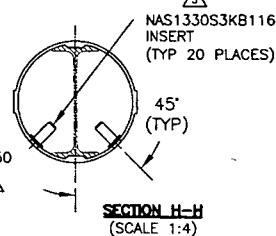
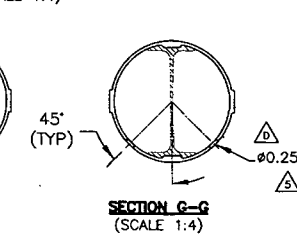
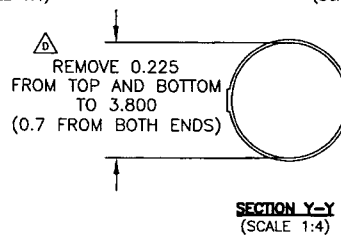
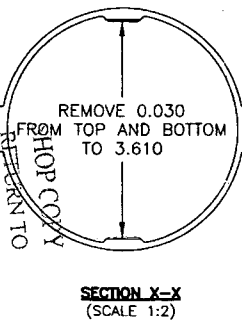
D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

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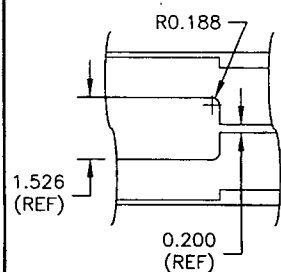
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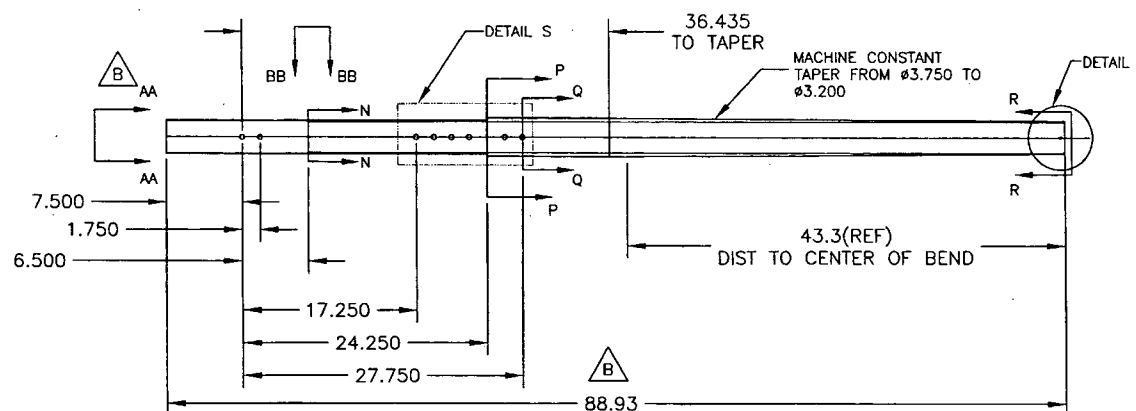
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APPROVED
TITLE
412 FLOAT SKIDTUBE

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REV. F
SHEET 3 OF 5
SCALE
1:20

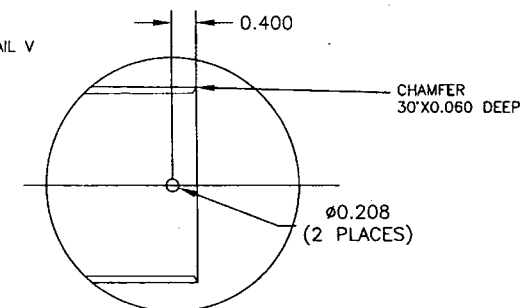
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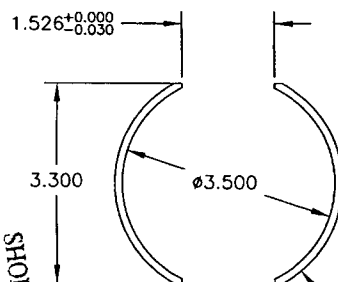
VIEW BB-BB
(SCALE 1:3)



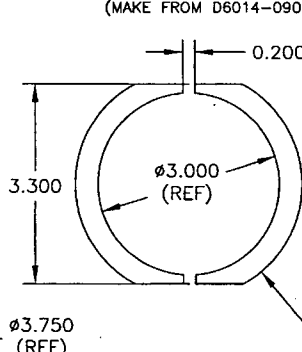
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



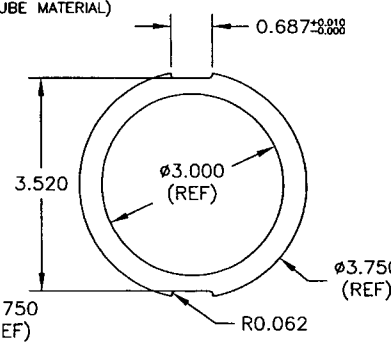
DETAIL V
(SCALE 1:2)



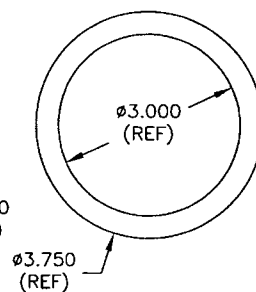
SECTION AA-AA
(SCALE 1:2)



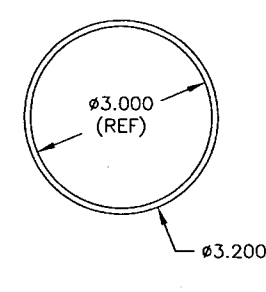
SECTION N-N
(SCALE 1:2)



SECTION P-P
(SCALE 1:2)

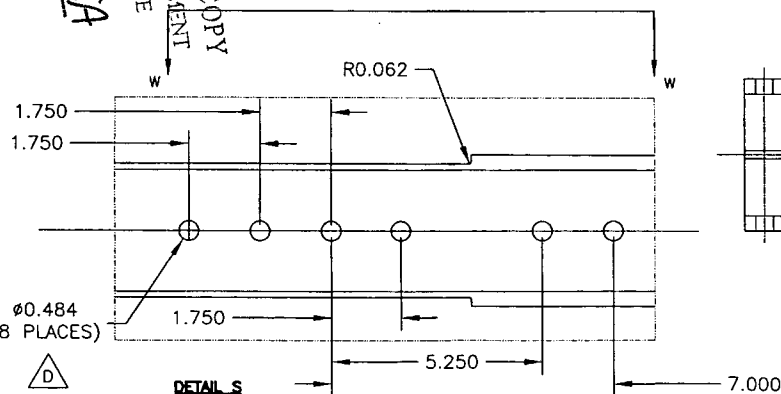


SECTION Q-Q
(SCALE 1:2)

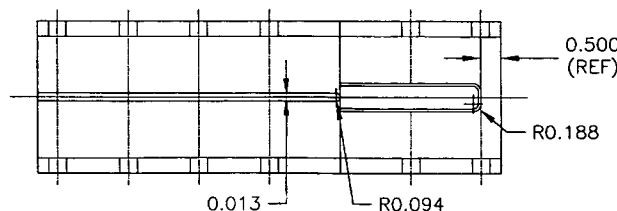


SECTION R-R
(SCALE 1:2)

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DETAIL S
(SCALE 1:3)



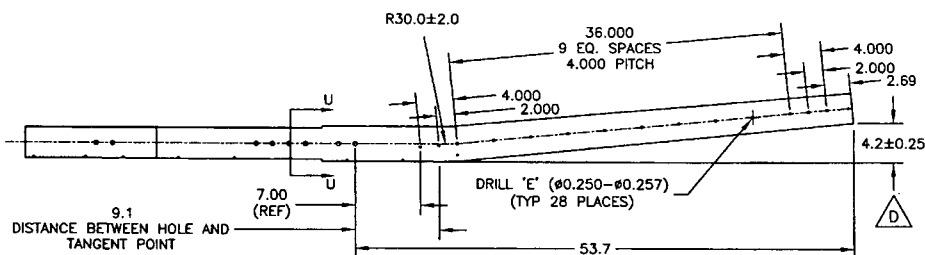
VIEW W-W
(SCALE 1:3)

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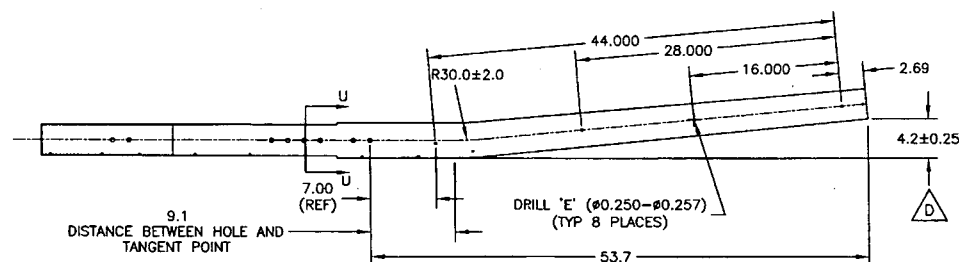
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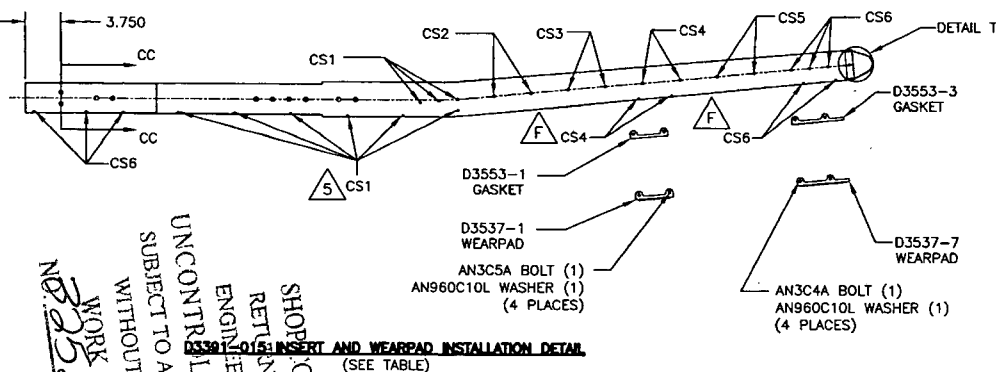
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
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DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



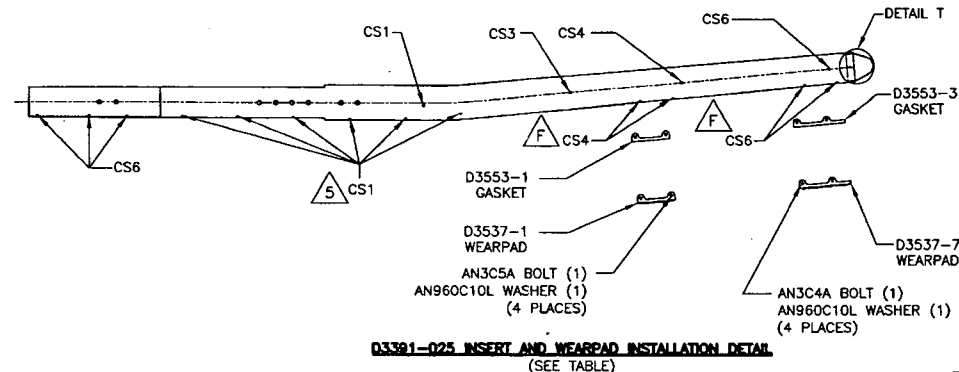
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



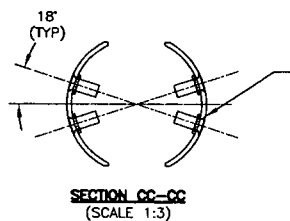
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

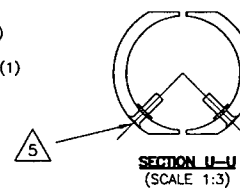
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	4	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	4	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

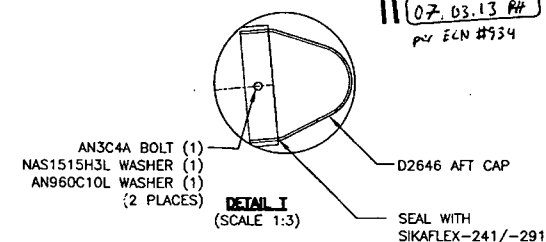


SECTION CC-CC
(SCALE 1:3)

DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



SECTION U-U
(SCALE 1:3)



DETAIL T
(SCALE 1:3)

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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